

Date: Tuesday, 21/10/2008 2:45:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 42772		
Estimate Number	: 10314		
P.O. Number	:	Part Number	: D265613
This Issue	: 21/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2656 REV D
First Issue	: //	Project Number	: N/A
Previous Run	: 40897	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>JUD 08-10-21</u>	Due Date	: 04/11/2008
Comment	: Est: F 02.10.25 Re-format KJ/RF	Qty:	10
	Est Rev:G Now on Waterjet 06-07-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
-----	------------	-----------------



Comment: Qty.: 0.8500 sf(s)/Unit Total : 8.5000 sf(s)
 1010/1025/A21/6aA SHEET

109289 HB 8-11-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D
 Prog Rev: D

HB 8-11-6

(13)

2-Deburr if necessary HB 8-11-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-11-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/11/06 (13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

EP 08/11/11 (13)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 2:45:41 PM
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Process Sheet

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Drawing Name: WEARSHOE

Job Number: 42772

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/12 (13)

7.0

POWDER COATING

POWDER COATING



M 106442



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
320°F
10:45

M-L 08/11/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-13 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P QO

M-L 08/11/13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/14

Job Completion



MF 08-11-13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

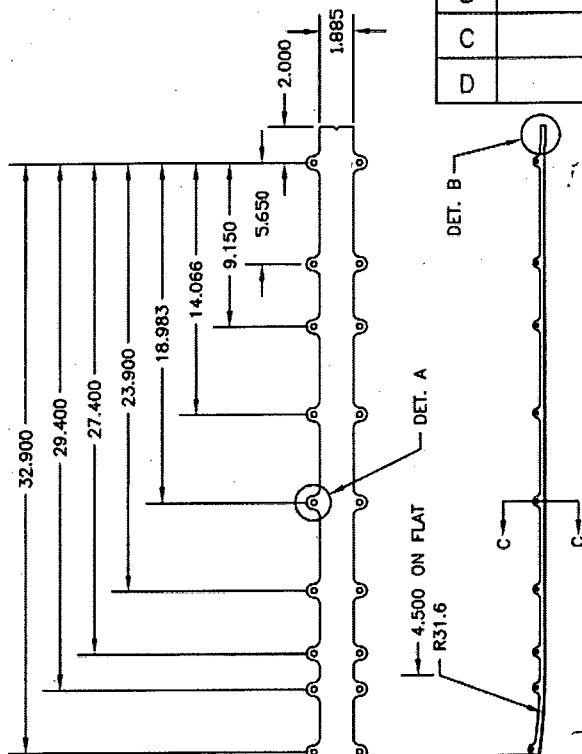
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

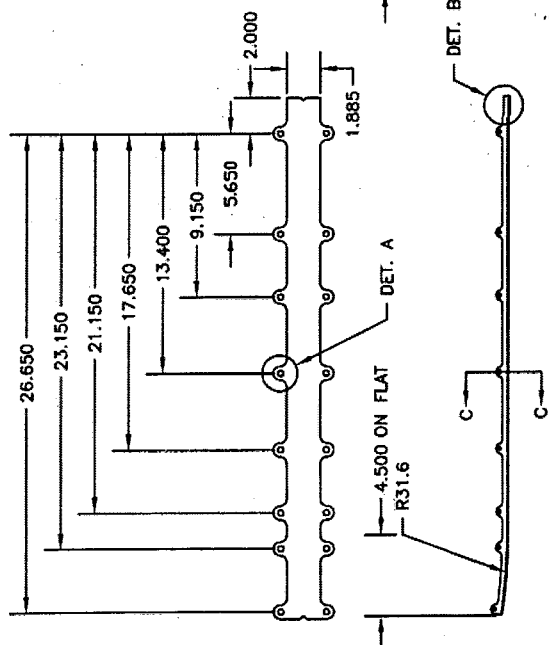


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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

D2656-13



D2656-11

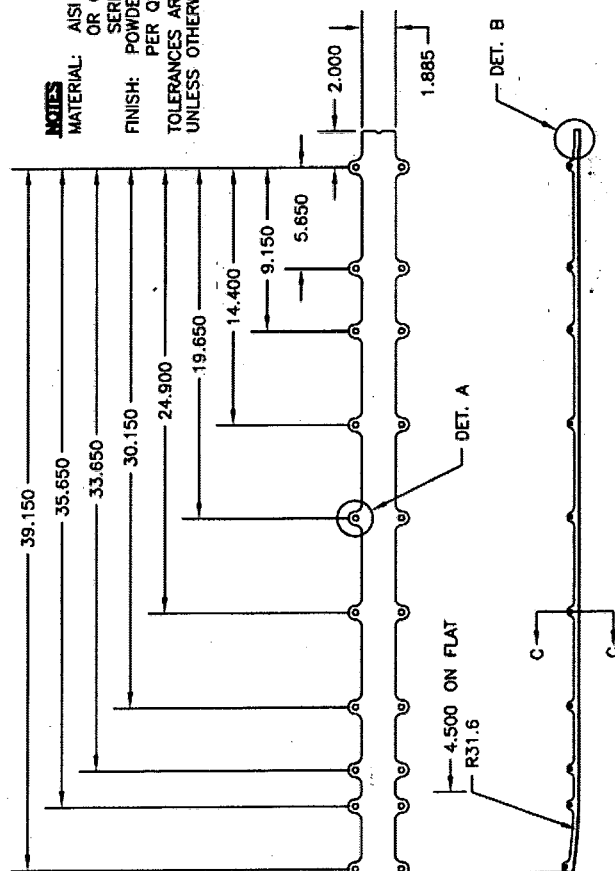


NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

D2656-15



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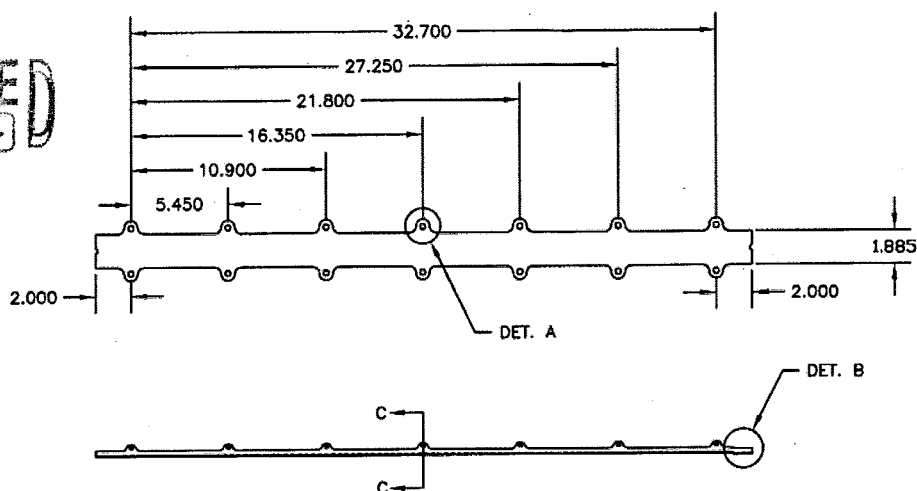
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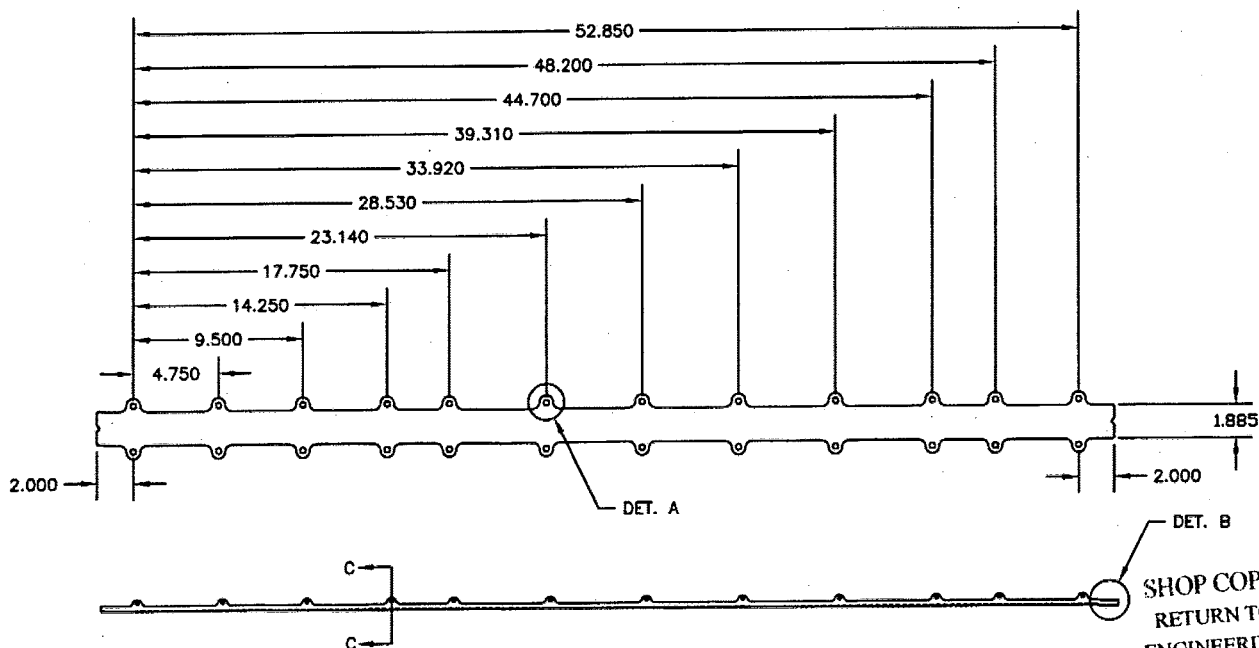
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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NO 42772

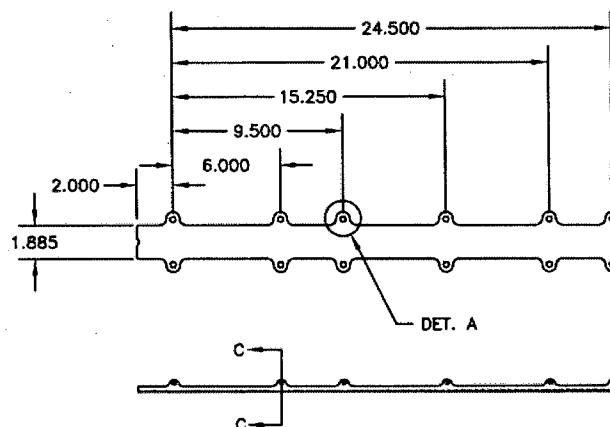
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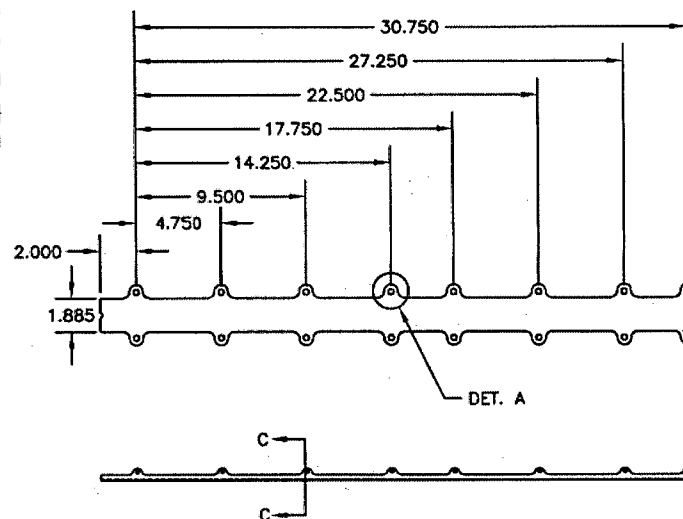


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		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

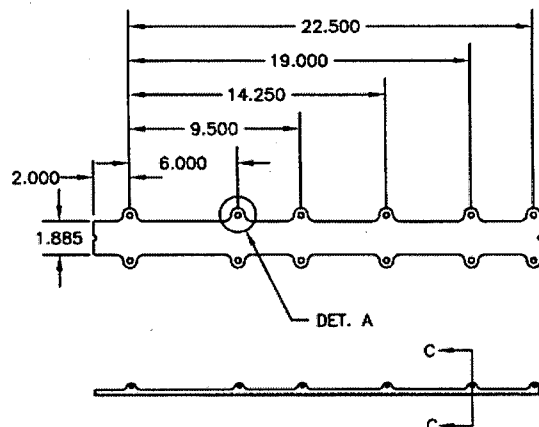
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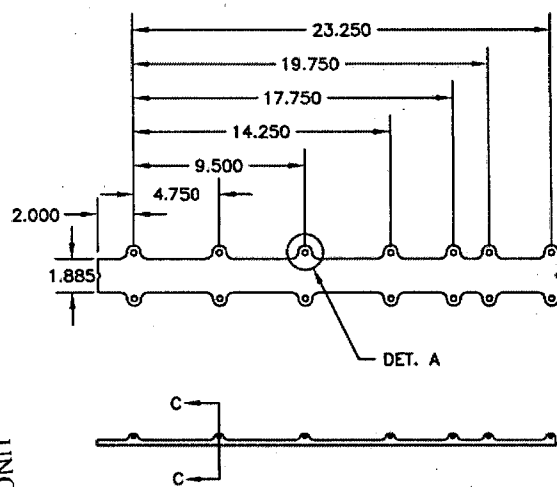
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D2656-31



D2656-35



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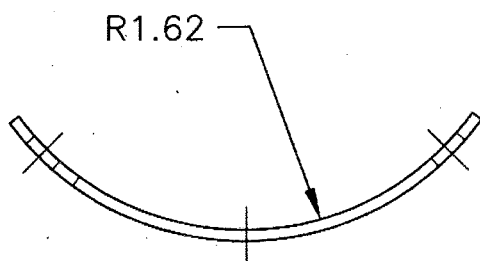
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NO 10/1/06



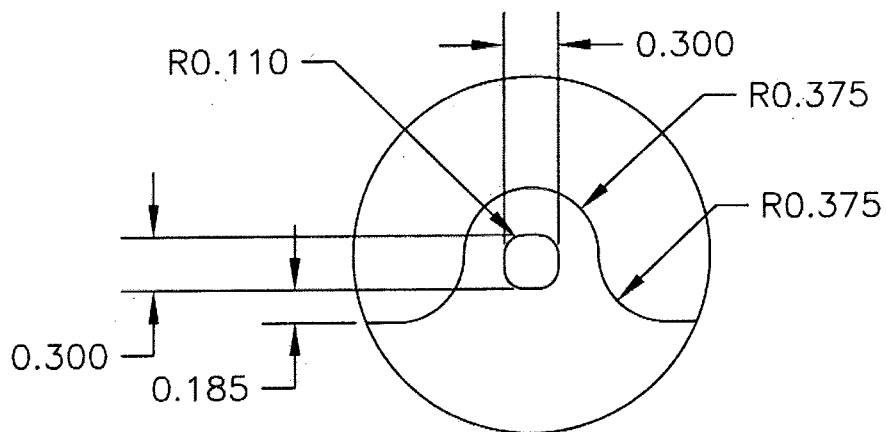
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

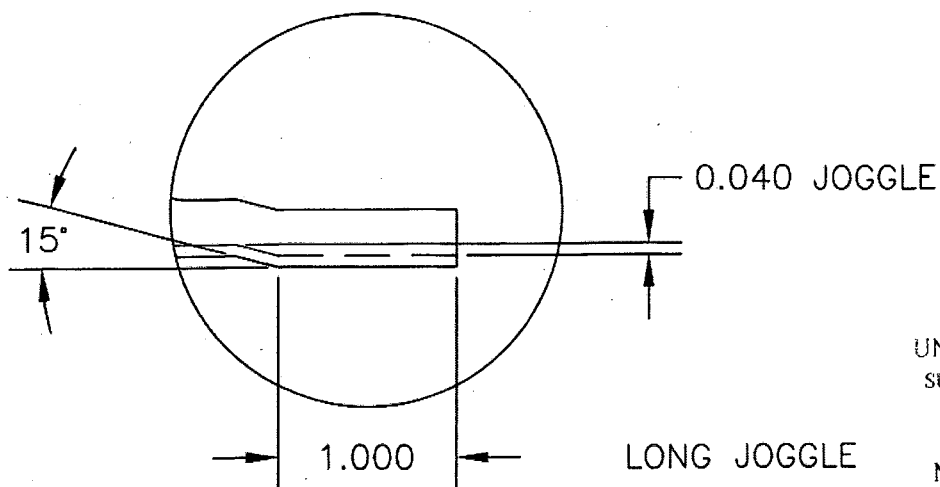


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DETAIL A



DETAIL B



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